

Work Order ID 57840

April 16, 2010 12:59:10 PM



Page 1

Item ID: D3049-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 4/19/10 Start Qty: 8.00



Cust Item ID:

Required Date: 4/23/10 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3049

Rev A1

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3049-1_BLANK

B 10-4-28

8

120

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1
3-Debur

anf 10/05/05

8

130

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

anf 10/05/05

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3049-1

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Required Date: 4/23/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Y.A 10/05/05

8

0

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Packaging

Memo

0.00

Packaging

10-5-6 SL

80

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/06

mf

10-5-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 57840



Parent Item: D3049-1



Parent Item Name: Bearpaw


Start Date: 4/19/10

Required Date: 4/23/10

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	212.0000	27.2000			



1810-4-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

212

112186

50

113903

162

112186

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	57840
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A Ø0.260	+0.005/-0.000	Ø.260	✓			
B 0.93	+/-0.030	.929	✓			
C 0.40	+0.030/-0.000	.412	✓			
D 2.00	+/-0.030	2.000	✓			
E 10.250	+/-0.010	10.250	✓			
F 4.540	+/-0.030	4.540	✓			
G 5.88	+/-0.030	5.880	✓			
H 0.38	+/-0.030	.380	✓			
I 11.50	+/-0.030	11.500	✓			
J 0.07 x 45°	+0.030/-0.010	.060 x 45°	✓			
K 0.44 - 0.47	+/-0.000	.460	✓			
L R0.25	+/-0.030	R.250	✓			
M 0.38	+/-0.010	.386	✓			
N 0.95	+0.030/-0.010	.955	✓			
O 0.69	+/-0.030	.680	✓			
P 0.20	+/-0.030	.193	✓			
Q 23.00	+/-0.030	23.000	✓			
R 0.25 x 45°	+/-0.030	.245 x 45°	✓			

Measured by: <i>mf</i>	Audited by: <i>H.A</i>	Prototype Approval:	N/A
Date: 10/05/05	Date: 10/05/05	Date:	N/A

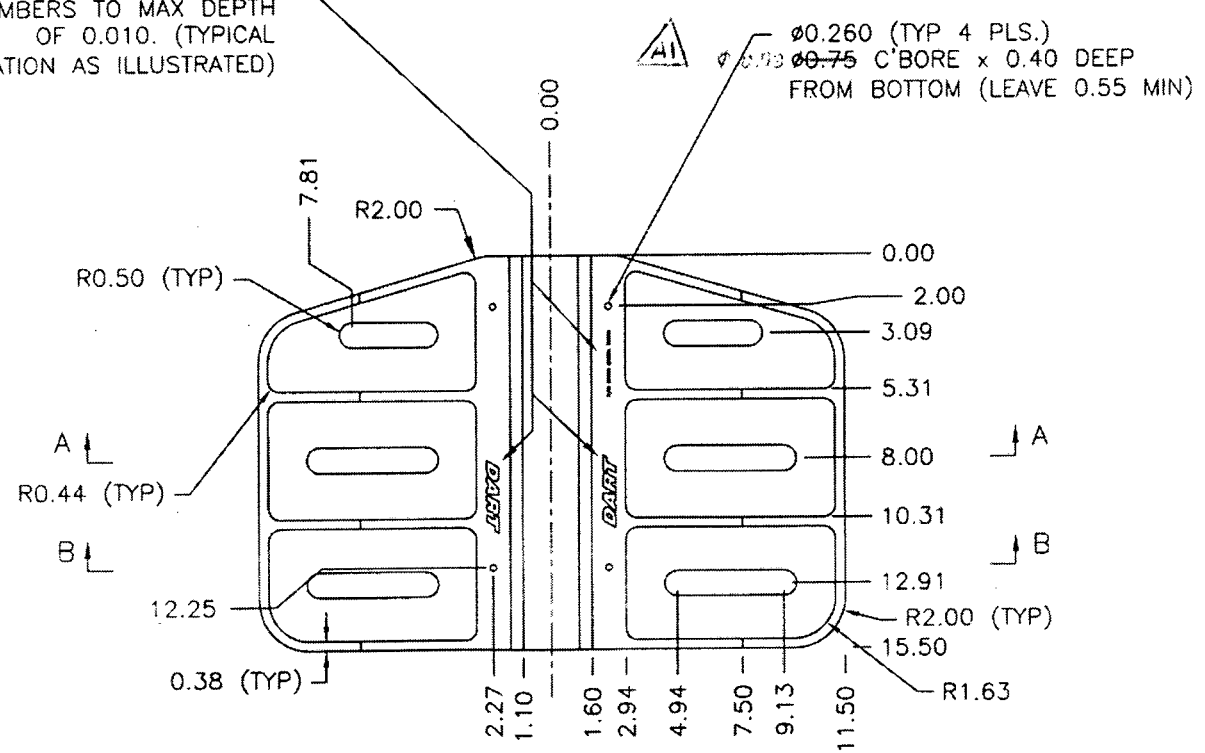
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD <i>JA</i>	<i>DA</i>



DESIGN KF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:1
A	01.10.18	NEW ISSUE	
AI	# RF 03.01.13 : 00.73 WAS 00.75		

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012:
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

- NOTES:
- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
 - 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

mo
57840

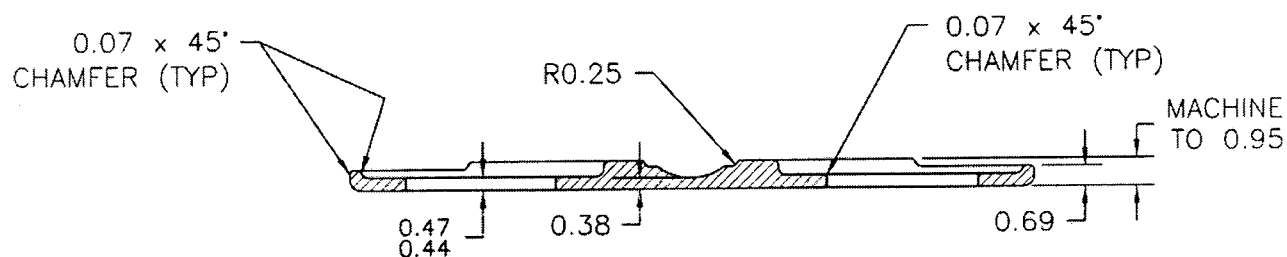
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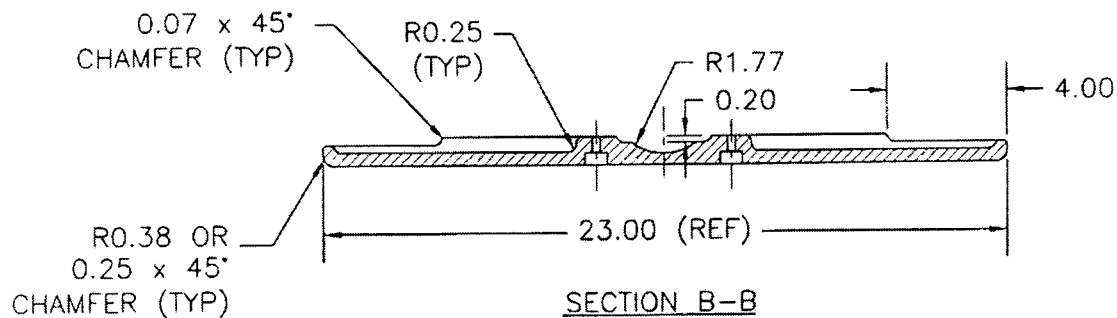


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.21



SECTION A-A



SECTION B-B

WLO
57840

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